Work Order ID 65339

January 12, 2011 11:44:45 AM

Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/01/12 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG002 none eurocopter								
110	Large Fab	0.00							
Large Fab	**Memo**	0.00							
Large Fab	1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M108436 M115928 3-Grind End Plate flush								

11 02 08

for CL 11-02-07

11.01.20 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65339

January 12, 2011 11:44:45 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00				2	0	BE 11/01/21	
QC	**Memo**	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00				x2 RH			
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				X2RH	0		
HandFinish	**Memo**	0.00							
Hand Finishing									

11/01/21

11/01/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65339

January 12, 2011 11:44:45 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				2	BL	11-a-24.	
QC	**Memo**	0.00							
Quality Control									
180		0.00				2			
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							

11-a-27

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R□□Aluminum Rod□ M102436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65339

January 12, 2011 11:44:45 AM

Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC9- Inspect visual per QSI004- Fusion Welds	0.00				2	0	BE	1/01/31
QC	**Memo**	0.00							
Quality Control									
200	QC5- Inspect part completeness to step on W/O	0.00				x2 RH			
QC	**Memo**	0.00							
Quality Control									
210	Chemical Conversion Coat per QSI005 4.1	0.00				2	BL	11-023	
HandFinish	**Memo**	0.00							
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65339

January 12, 2011 11:44:45 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				2		BL 11-02-10	
Powdercoat	M115951.								
Powder Coating	**Memo** START TIME: 7:50 OVEN TEMPERATURE 320° FINISH TIME: 8:20.	0.00							
230	Wing Walk as per dwg QSI005 4.4 Batch M11164080	JL 11/02/10				V2	ø		
HandFinish									
Hand Finishing	**Memo**	0.00							
240	QC3- Inspect Part Finish	0.00				11/9 SJ RD			
QC									
Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65339

January 12, 2011 11:44:45 AM

Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00				11	0		SL (2)
Packaging	**Memo**	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00				11	02	08	(2)
QC	**Memo**	0.00							
Quality Control									
270	Packaging	0.00				11	2	9	SL (2)
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312 Location: 81								

REQ'D

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D350-591-312 **Accept** **Setup Start**
Revision ID: **Stop**
Item Name: Heli-Access-Step, Long RH
Start Date: 1/12/11 **Start Qty:** 2.00 **Cust Item ID:**
Required Date: 1/26/11 **Req'd Qty:** 2.00 **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00					11/02/09		MP
QC	**Memo**	0.00							
Quality Control									

MP
11-02-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:44:43 AM

Work Order ID: 65339

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Required Date:** 1/26/11

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A□04.03.22□New issue □KJ/RF□
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D
fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011 Step Modification		Manufactured	No				Each	2.0000	1	2	2	11/8/11	
				Location			**Loc Qty**	**Loc Code**					
				FG020			2						
					63714		2						
D3272-1 Step		Manufactured	No			110	Each	8.0000	1	2	2	11.01.20	
				Location			**Loc Qty**	**Loc Code**					
				WA	365342		8						
					64912		8						
D3067-1 End Plate		Manufactured	No			110	Each	76.0000	1	2	2	11.01.20	
				Location			**Loc Qty**	**Loc Code**					
				WA			76						
					63550		76						
D3219-1 Plate		Manufactured	No			110	Each	73.0000	2	4	4	11.01.20	
				Location			**Loc Qty**	**Loc Code**					
				WA			73						
					63551		73						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:44:44 AM

Work Order ID: 65339

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Required Date:** 1/26/11

Start Qty: 2.00 **Required Qty:** 2.00

D3066-1	Manufactured	No		180	Each	96.0000	2	4

Spacer

Location	Loc Qty	Loc Code	
WA	96		
63549	46		4
65072	50		

MS20600-AD4W4	Purchased	No		180	Each	2,031.000	16	32

Rivets

Location	Loc Qty	Loc Code	
ST321	2031		
113368	38		
114181	11		
114718	2		
115573	147		22
115640	31		
116022	302		10
116188	1500		

D3065-041	Manufactured	No		180	Each	22.0000	1	2

Step Leg Assembly Hi

Location	Loc Qty	Loc Code	
WA	22		
63555	22		2

D3067-1	Manufactured	No		180	Each	76.0000	1	2

End Plate

Location	Loc Qty	Loc Code	
WA	76		
63550	76		2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:44:44 AM

Work Order ID: 65339

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Required Date:** 1/26/11

Start Qty: 2.00 **Required Qty:** 2.00

AN3-35A Bolt		Purchased	No		250	Each	168.0000	2	4 M116704 11/2/85

Location	Loc Qty	Loc Code
ST353	168	
116191	100	
116419	18	
116549	50	

D3235-1 Mounting Lug		Manufactured	No		250	Each	61.0000	2	4 B65073 11/2/85

Location	Loc Qty	Loc Code
ST471	61	
61845	1	
63547	60	

D3278-041 Support Assembly		Manufactured	No		250	Each	8.0000	1	2 B63553 11/2/85

Location	Loc Qty	Loc Code
ST460	8	
64731	8	

AN960JD416 Washer	NAS1149D0463J	Purchased	No		250	Each	30.0000	16	32 M116304 11/2/85 (2)

Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:44:44 AM

Work Order ID: 65339

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Required Date:** 1/26/11

Start Qty: 2.00 **Required Qty:** 2.00

AN960JD516 NAS1149D0563J Washer	Purchased	No		250	Each	34.0000	4	8	M114742 11/12/8 SL

Location	Loc Qty	Loc Code
ST	34	
103694	18	
107534	12	
109287	4	

AN5-36A Bolt	Purchased	No		250	Each	151.0000	2	4	11/12/8 SL

Location	Loc Qty	Loc Code
ST341	151	
114292	1	
116191	100	4
~~116549~~	50	

D2618 Bushing	Manufactured	No		250	Each	99.0000	2	4	11/12/8 SL

Location	Loc Qty	Loc Code
ST019	99	
63548	36	
65071	63	4

D2230-3 Lug	Manufactured	No		250	Each	94.0000	4	8	B65067 11/12/8 RD

Location	Loc Qty	Loc Code
ST476	94	
55452	2	
63312	12	
64422	80	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:44:44 AM

Work Order ID: 65339

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Required Date:** 1/26/11

Start Qty: 2.00 **Required Qty:** 2.00

D2856-400 Abraison Strip	Manufactured	No		250	f	272.5810	1.2	2.4

Location	Loc Qty	Loc Code	
ST403	272.5810421		
56626	0.00004211		
59920	56.581		
63735	216		2.4

cut (2) D2856-400-720 as per dwg

MS21042L3 Nut	Purchased	No		250	Each	3,264.000	2	4

Location	Loc Qty	Loc Code	
ST300	3264		
114784	9		
115835	755		4
116391	900		
116540	800		
116549	800		

AN4-13A Bolt	Purchased	No		250	Each	179.0000	8	16

Location	Loc Qty	Loc Code	
ST357	179		
116191	179		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:44:44 AM

Work Order ID: 65339

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 **Required Date:** 1/26/11

Start Qty: 2.00 **Required Qty:** 2.00

MS21042L5		Purchased	No		250	Each	1,353.000	2	4

Nut

x2

Location	Loc Qty	Loc Code
ST139	26	
114813	26	
ST300	1327	
115156	5	
115594	500	
~~116104~~	126	
116105	496	
116548	200	

MS21042L4		Purchased	No		250	Each	4,788.000	8	16

Nut

x2

Location	Loc Qty	Loc Code
ST300	4788	
1123143	2	
115589	10	
115621	276	
116188	3500	
116548	1000	

AN960JD10	NAS1149D0363J	Purchased	No		250	Each	8.0000	4	8

Washer

x2

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3272	SHEET 1 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07 06 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65339
CL 11/01/12

Copyright © 2004 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

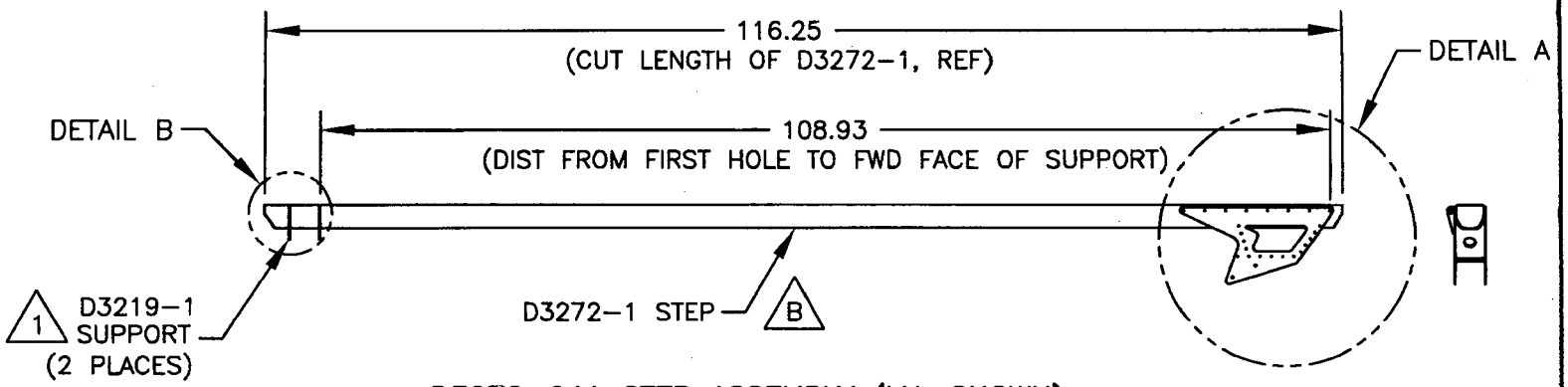
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

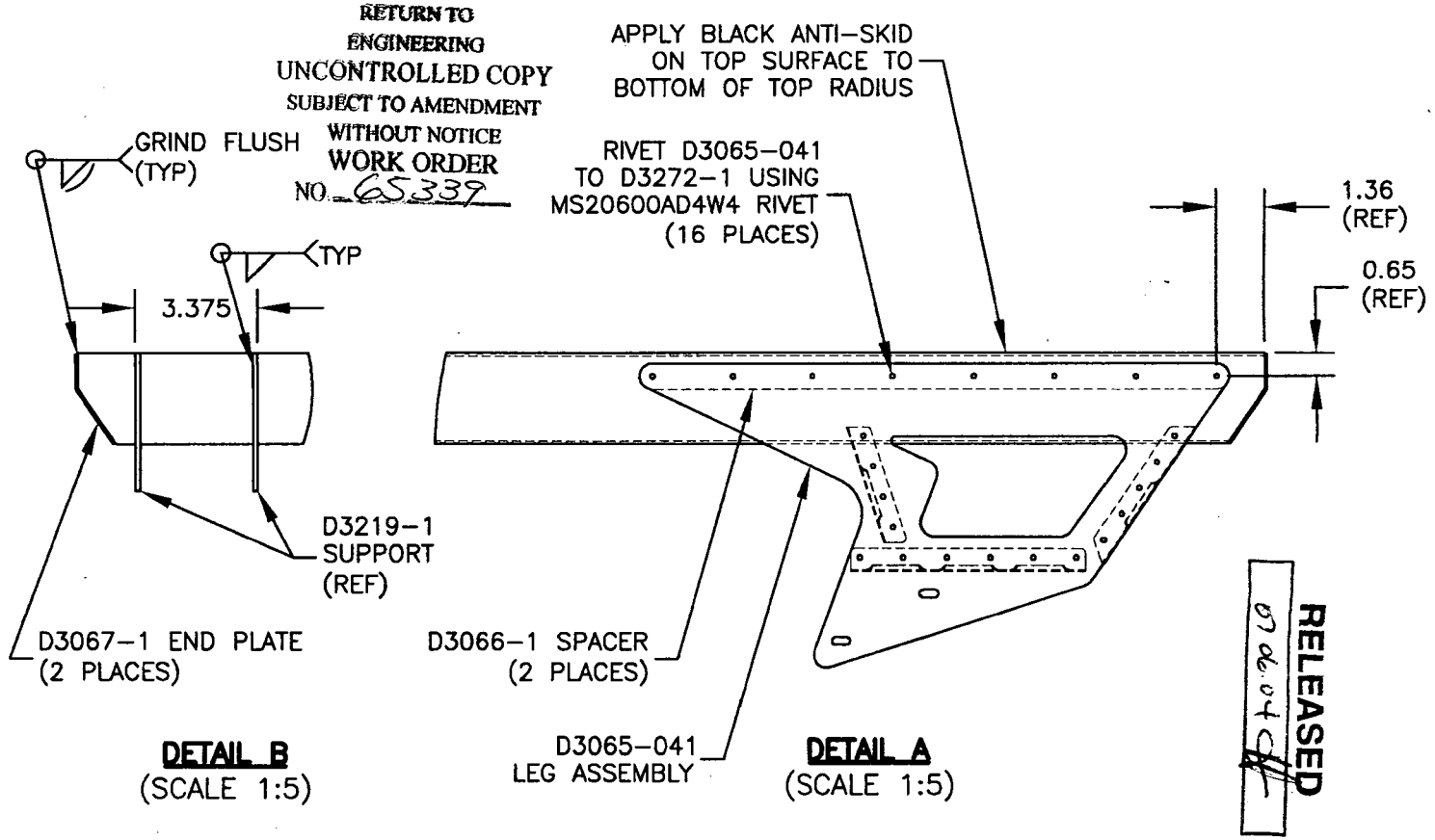
NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65339



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07 de 04

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
		D3272	B
CHECKED	APPROVED		SHEET 2 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

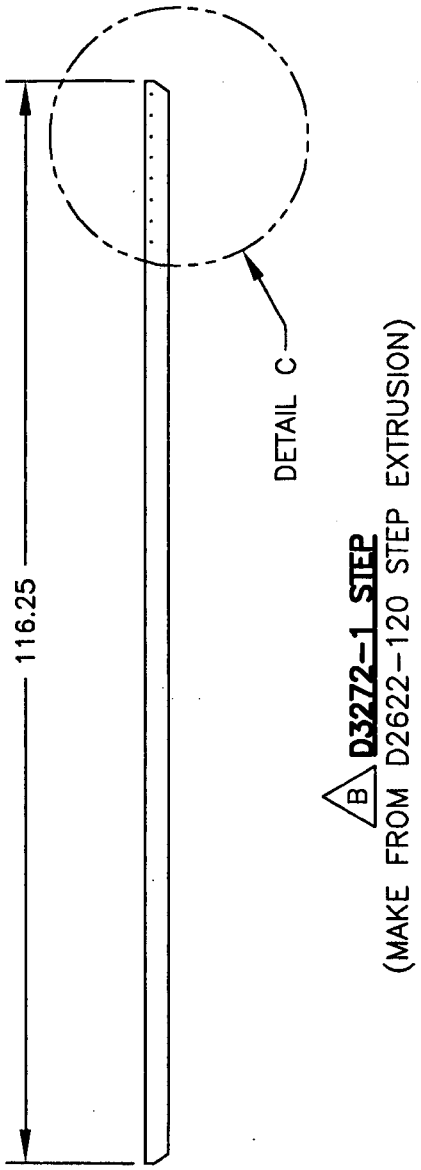
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

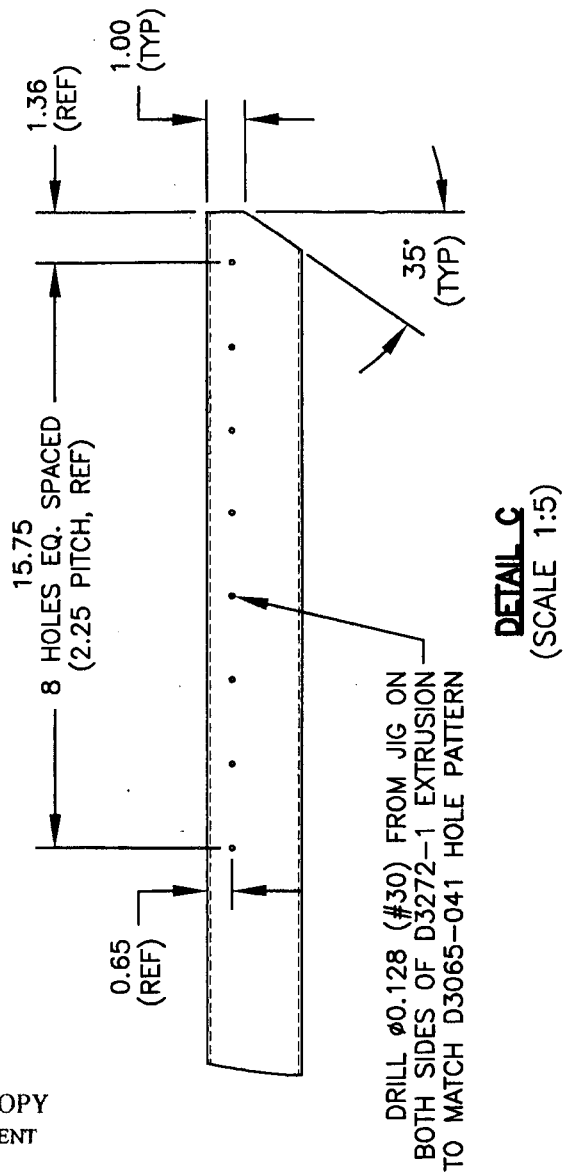
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07.06.04



(B) **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65339

Copyright © 2004 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	***Heli-Access-Step***™, Long Step – High Skid, LH
	X							D350-591-212	***Heli-Access-Step***™, Long Step – High Skid, RH
		X						D350-591-213	***Heli-Access-Step***™, Short Step – High Skid, LH
			X					D350-591-214	***Heli-Access-Step***™, Short Step – High Skid, RH
				X				D350-591-215	***Heli-Access-Step***™, Short Step – Low Skid, LH
					X			D350-591-216	***Heli-Access-Step***™, Short Step – Low Skid, RH
						X		D350-591-311	***Heli-Access-Step***™, Long Step – High Skid, LH
							X	D350-591-312	***Heli-Access-Step***™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

• COPYRIGHT © 1993 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.